Monday, 28/05/2007 9:08:16 AM

Hiser

Linda Lacelle

**Process Sheet** 

Customer Job Number : CU-DAR001 Dart Helicopters Services

: 31923

**Estimate Number** 

: 11230

P.O. Number This Issue Prsht Rev.

First Issue

: 4/4 : 28/05/2007

S.O. No. : 2/1

: 31923

Type

: SMALL /MED FAB

Part Number

**Drawing Name** 

**Drawing Number** 

: D2369 REV A : N/A **Project Number** 

**Drawing Revision** 

Material **Due Date** 

: D23693

: BRACKET LOCATOR

Qty:

Um: Each

**Previous Run** Written By

Checked & Approved By Comment

Est Rev:B

Removed from 9 Digit 05-12-05 JLM

Now on Waterjet 07-05-28 JLM

**Additional Product** 

Job Number:



Seq. #:

**Machine Or Operation:** 

**Description:** 

M5052H32S040 1.0



5052-H32 .040 Sheet



Comment: Qty.: 1.4217 sf(s)/Unit Total: 14.2170 sf(s) Material: 5052-H34 or H32 0.040" thick

(M5052H32S.040)

Batch: \_ M I

SAD

07/05/31



FLOW WATER JET



Comment: FLOW WAT QC2

SAD INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAN



SECOND CHECK



4.0 QC8



Comment: SECOND CHECK

SMALL & MEDIUM FAB RESOURCE 1



5.0

6.0

3.0

SMALL FAB

Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr



040

QC5



Comment: INSPECT WORK TO CURRENT STEP

Date:

Monday, 28/05/2007 9:08:16 AM

User:

Linda Lacelle

**Process Sheet** 

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET LOCATOR

Job Number: 31923

Part Number: D23693

Job Number:



Seq. #:

**Machine Or Operation:** 

Description:

7.0

PACKAGING 1

PACKAGING RESOURCE #1





Comment: PACKAGING RESOURCE #1

Identify and Stock-

Location:

QC21



8.0



Comment: FINAL INSPECTION/W/O RELEASE



Job Completion



mi recolit



Date:

Tuesday, 4/17/2007 3:56:20 PM

User:

Kim Johnston

## **Process Sheet**

Customer Job Number : CU-DAR001 Dart Helicopters Services

: 31923

**Estimate Number** 

: 11230

P.O. Number This Issue

Prsht Rev.

: 4/17/2007

S.O. No. :

: NC

: // First Issue

Previous Run

Type : MACHINED PARTS **Part Number** 

**Drawing Name** 

: D23693 D2369 REV A

: BRACKET LOCATOR

**Drawing Number** 

: N/A : A

Project Number

**Drawing Revision** 

Material

Due Date

: 5/2/2007

Qty:

10 Um:

Each

PLO

Written By Checked & Approved By

Comment

: Est Rev A

Removed from 9 Digit

05-12-05 JLM

**Additional Product** 

Job Number:



Seq. #:

Machine Or Operation:

Description:

5052-H32 .040 Sheet

1.0

M5052H32S040



Total:

Comment: Qty.: 1.4217 sf(s)/Unit

Material: 5052-H34 or H320.040" thick

(M5052H32S.040) Batch:

2.0

SHEAR

14.2170 sf(s)

SHEAR

Comment: SHEAR

Cut blanks: 39.0" x 5.00

3.0

HAAS1

CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine D2369-3 as per Folio D2369-3 and Dwg D2369

4.0

QC2

INSPECT PARTS AS THEY SOME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0

QC8



· SECOND CHECK



Comment: SECOND CHECK

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr



## **Dart Aerospace Ltd**

W/O:	:	WORK ORDER O	HANGES					
DATE	STEP	PROCEDURE CHANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
<u>                                     </u>								

Part No:	PAR #:	Fault Category:	NCR: Yes No I	DQA:	Date:
			QA: N/C Clo	sed:	Date:

NCR:		W	ORK OR	DER NON-CONFORMANO	CE (NCR)			
	_	Description of NC		Corrective Action Section B		Verification	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	QC Inspector
0405 31	2,6	hole's on Part were to big had to change the effect		Serap destroy - replace  Oty I point	5.40 व्यक्ति ह्य	São	1	G
		la Hammon error	OSIUL Z			०मी०विष	fesiw2	07/06/18
07/05/3		0.050" thise is know	1851 OUZ	Parts are	5AV   05	Š		<u></u>
	290	0040' mol.	10000			08	Casi ouz	
		e.C. Hummon even		4		<u> </u>		-
	-							

NOTE: Date & initial all entries

Date: ' User:

Tuesday, 4/17/2007 3:56:20 PM

Kim Johnston

**Process Sheet** 

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET LOCATOR

Job Number: 31923

Part Number: D23693

Job Number:



Seq. #:

**Machine Or Operation:** 

Description:

7.0

INSPECT WORK TO CURRENT STEP

Comment: INSPECT WORK TO CURRENT STEP ...

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock Location:

FINAL INSPECTION/W/O RELEASE



9.0



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



## **Dart Aerospace Ltd**

Dail Ae	lospace Liu								
W/O:			WORK ORDER	CHANGES					
DATE	STEP	PRO	OCEDURE CHANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspecto
				· · · · · · · · · · · · · · · · · · ·			_		
Part No	:	PAR #:	Fault Category:	NC NC	R: Yes	No DQ	A:	Date:	
								Date: _	
NCR:		,	WORK ORDER NON-CO	NFORMANCE	E (NC	R)			

NCR:		W	ORK ORDE	ER NON-CONFORMANO	CE (NCR)			
_ 1		Description of NC		Corrective Action Section B	,	Verification	Annewal	Annewal
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	31923
Description: Deck Plate Locator Bracket	Part Number:	D2369-3
Inspection Dwg: D2369 Rev: A		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

X	First Article		Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.500	+/-0.010	0.608			Vern	
4.500	+/-0.010	4,499			Vern	
5.709	+/-0.010	51716	/		Vern	
Ø0.128	+0.005/-0.000	00.130			Vern	
37.990	+/-0.010	37,990	V		MITFU	gris
38.297	+/-0.010	38,300	1/		M-The	na
5.000	+/-0.010	5.004			Vern	
4.490	+/-0.010	4,493	/		Vern	
0.664	+/-0.010	0.668			Vern	
39.000	+/-0.010	39,000	/		M-T/Ve	m
38.528	+/-0.010	38. <b>53.0</b>	/		M-T Gver	1
					,	
		(1)				

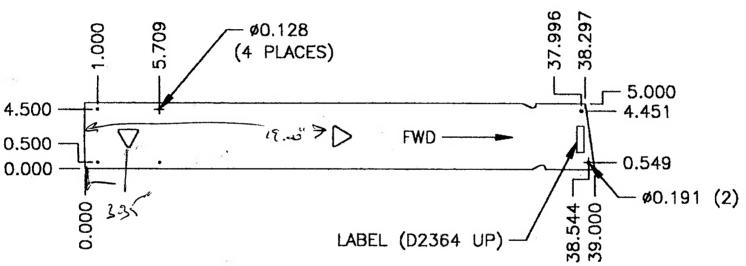
Measured by: SAN	Audited by:	Prototype Approval:	N/A
Date: 07/05/31	Date: 0106/18	Date:	N/A

Rev	Date	Change		Revised by	Approvéd
Α	04.06.25	New Issue	P/O D350-616-015	KJ/JLM 🛠	
					7 7



	(Sat			2
08-03-30	1 3 2 T	CHECKED	WILLIAMS	DESIGN
•		STANDINGS	B WILLIAMS B WILLIAMS	DRAWN BY
DECK DI ATE I	D2369	DRAWING NO.		DART
DECK BLATE LOCATOR BRACKET			VICTORIA INTERNATIONAL AIRPORT, CANADA	DART AEROSPACE LTD
	SHEET 1 OF		CANADA	
	Q	<b>R</b> V. /		

EASE



UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT MOTICE SHOP COPY RETURN TO ENGINEERING

D2369-1

MATERIAL: 5052-H34 0.040 THICK





DESIGN	DRAWN BY	DART AFROSPACE LTD
B WILLIAMS B WILLIAMS	B WILLIAMS	
CHECKED	APPROVED	DRAWING NO. REV. A
30	产	D2369 SHEET 2 OF 2
DATE	_	TITLE
95:02:20		DECK PLATE LOCATOR BRACKETS 1:7

